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D3200-3
Job Sheet 182258



Part No: D3200-3

Part Name: Door Wedge



Part Weight: 0 lbs

Job Created: 8/21/18

Due Date: 9/7/18

Type: Stock

Note: DWG REV A IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Ship Via:

Job Qty: 4 ea

22 2018

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-2		DAS 18/09/18
100	Bandsaw	4 pcs	9/7/18	9/7/18	0.00	0.13	Bandsaw1		52 18/09/18
110	CNC Vertical Machining	4 pcs	9/7/18	9/7/18	0.07	0.91	HAAS1-3		9-89 18/09/18
130	QC	4 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-2		J.C.L. 18-09-18
140	Packaging	4 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1	SK23	DAS 18/09/18
150	QC21-SA	4 Ea	9/7/18	9/7/18	0.00	0.00	QC21		6 21 9-89 SEP 17 2018

Part Op 100 - Cut blank: 1.000 X 1.970"

Descriptions: 110 - 1-Machine D3200-3 as per Folio FA337 and Dwg D3200

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	.0600 sf (.015 ea)	90-Start up Operation	FA337-153 8045595

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	0	1,051	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Wedge	0.196inches + 0.005 - 0.000	0.201 0.196	0.197	
2	Door Wedge	0.405inches ± 0.010	0.415 0.395	0.405	
3	Door Wedge	100.000Degrees ± 0.000	100.000 100.000	100°	
4	Door Wedge	0.500inches ± 0.010	0.510 0.490	0.500	
5	Door Wedge	1.722inches ± 0.010	1.732 1.712	1.722	
6	Door Wedge	0.380inches ± 0.010	0.390 0.370	0.379	DAS 52 18/09/18 9-89
7	Door Wedge	0.750inches ± 0.030	0.780	0.752	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date : _____

D

Container No: S109523
 Part: D3200-3
 Job No: 182258
 Serial No/ Batch: S109523
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 09/12/18

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Work Order update only ☐

DEPARTMENT/PROCESS

Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

Engineering ☐
 Quality ☐
 Other ☐

MRB (QSI042) Approval

Completed By

Lead hand / Supervisor
 Approval Verification

QC / QA Coordinator
 Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

OTHER :

				0.720	
8	Door Wedge	0.015inches	+ 0.050 - 0.000	0.065 0.015	035

Plex 8/21/18 11:07 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								